



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3407-5
Job Sheet 168902



Part No: D3407-5

Job Qty: 20 ea

Part Name: Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/24/17

Job Tracking No:

Due Date: 12/1/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		11/30/17	0.00	0.00	Start Up Waterjet		DL 18/01/09
100	Waterjet	20 pcs		11/30/17	0.03	1.83	Waterjet1		DL 18/01/09
110	QC	20 pcs		11/30/17	0.00	0.00	QC2		DL 18/01/09
115	Lathe Conv	20 pcs		12/1/17	0.00	1.32	Lathe Conv-1		J.C.L.
117	QC	20 pcs		12/1/17	0.00	0.00	QC2		J.C.L. 18/01-15
120	QC	20 pcs		12/1/17	0.00	0.00	QC8		DL 18/01/12
130	Packaging	20 pcs		12/1/17	0.00	0.00	Packaging3		DL
140	QC21-SA	20 Ea		12/1/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: G Prog Rev: G 2-Break edges on manual lathe Dwg D3407
Descriptions: (175rpm)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M174PH-H900B0.250X4.000	5	0	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches $\pm$ 0.010	0.260 0.240		
2	Tow Ring	3.000inches $\pm$ 0.030	3.030 2.970		
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049		
4	Tow Ring	0.750inches $\pm$ 0.030	0.780 0.720		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Water Jet ☐ or. ☐ ing ☐ lier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Ring D3407-5 Start up Operation Mfg Date: 01/09/18 Job No: 168902 PART NO: Revision: Operation: Change No:					
Description Work Order Deviation		MRB (QSI042) Approval _____							
_____		Completed By _____							
Root Cause		Lead hand / Supervisor Approval Verification _____							
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